Work Order ID 87475 *87475* Page 1 July-19-12 10:06:26 AM Accept D412-726-142 *N900040100* Setup Start Item ID: **Revision ID:** Wearplate RH Item Name: Start Oty: 1.00 7/10/12 **Cust Item ID: Start Date:** Req'd Qty: 1.00 Required Date: 8/03/12 **Customer:** Reference: Run Start Process Plan: MJ 19 Tooling: Date: 12 07 Date: Approvals: Stop Date: QC: SPC (Y/N): Date: Sequence ID/ Tool ID Tool # Plan Reject Reject Operation Set Up/ Accept Insp. Qty Qty Work Center ID Description Code Number Stamp **Run Hours Revision Nbr Draw Nbr** N/A Rev N/A 0.00 100 DOCUMENT CONTROL *100* DC Memo Photocopy bluefile and create labels per PPP D412-726 142 Document Control 0.00 110 Pick Kit *110* 0.00 Packaging Memo Packaging QC4-100% Inspect kits for completeness 120 *120* QC Memo Quality Control

NCR:	Yes	/	Nο

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:			<u> </u>	
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	·								QA Closed:	Date:				
Work Order: DISPOSITION							AGAINST DEPARTMENT/PROCESS							
Part No.					Rework Scrap		Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality			
NCR N	NCR No.				Use-as-is Work Order Update	Ther	Thermoforming Finishing F Large Fab Composite			re/Packaging Supplier	Other			
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &					
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector			
Doc/Data					1 11 11 11 11 11									
Equip/Tooling														
Operator							·							
Material							·							
Setup									,					
Other 1														
Process														
Supplier		l									· -			
Training														
Unapproved					•	*								
					F	AULT CAT	EGORY							
Landin	ng Gear				General						<u> </u>			
	Bending				Bend	Grain			Ovalized		Pressure/Forced			
	Centre No	ot Concer	ntric to (o/s	BOM/Route	Hardw	Hardware		Over/Under	tolerance	Temperature/Cure			
	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld			
	Crushed/Crimped.			Burrs	Instruc	ctions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled				
	Cuffs Contamin				Contamination	Maint	enance		Part Moved	_				
	Heat Treat Countersin				Countersink	Mislab	eled		Positioned \	Vrong				
[Inspection	n Strip in	Tube		Cut Too Short	Misrea	ad	:	Power Loss/	Surge	Other			
	Ripples in	Bend			Drill Holes	Offset								
	Torque W	/aves in E	xtrusior	۱ [Drawing	Out of	Calibration							
	Turning S	equence			Finish	Out of	Sequence							
ſ	Wave/Tw	ist in Tub	e		Folio	Outsid	le Dimensions							

Work Orde July-19-12 10:0		1/5					Page 2					
Item ID: D412-726-142 Revision ID: Item Name: Wearplate RH		2		Accept	*N900)* s	etup Sta		NS1* NS2*			
Start Date: Required Date: Reference:	7/10/12 8/03/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:	D:						
Approvals:			Date:	Tooling: SPC (Y/N):	Date:			R		on	*NR1* *NR2*	
Sequence ID/ Work Center II 130 *130* Packaging)	Operation Description Packaging Memo		Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Rejec Numl		_
Packaging 140 *140* QC Quality Control		Identify and 142Location QC21- Final Inspection Memo							<u>_</u> _ <u>_</u> <u></u>	2/	7/19/ MF 12-09/	-18 D
		4 •	·								12-09/	שן

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:		
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	•										QA Closed:	Date	e:
Work Orde	Jork Order: DISPOSITION									/PROCESS			
Part N	·					Rework Scrap		ſ	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	No					Use-as-is Work Order Update] !r		noforming Large Fab	Finishing	Rec/Stoi	re/Packaging Supplier	Other
Root					Descri	ption of work order update	Initia	al	Ac	tion	Sign &		
Cause	Da	te S	Step	Qty		or Non-conformance	Chief I	Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
	<u></u>	L	I	L.,1		F	AULT C	ATE	GORY		1	<u> </u>	
Landir	ng Gear					General							
Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	Insp Inst Ma Mis Mis Off	dwa pecti ruct inte labe read set t of C	on Incomplete ions Incomplete/ nance led i Calibration Sequence	Unclear	Ovalized Over/Under Part Incorred Part Lost/M Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other			
	Wave	/Twist	in Tub	e ·		Folio	I lout	tside	Dimensions				

Picklist Print July-19-12 10:06:26 AM Work Order ID: 87475 **Start Date: 7/10/12** Required Date: 8/03/12 D412-726-142 Parent Item: Start Qty: 1.00 Required Qty: 1.00 Parent Item Name: Wearplate RH Comments: IPP Rev:A05.05.12New issueKJ/JLM Qty per Kit Total Unit of Qty on Qty Component Item ID/ Replacement Mfg/ Last Route Bin **Primary** Item Name Location Measure Hand Issued Issued Item ID Location Seq ID Qty Purch Item AN3-5A 120 Each 1,211.0000 No Purchased Bolt Location Loc Qty Loc Code ST350 1211 115371 46 117423 121 119355 200 120187 338 121185 6 500 122416 AN960JD10L 120 0.0000 NAS1149D0332J No Each Purchased M122973 Washer 120 Each 2.0000 D3315-2 No Manufactured Wearplate

Location

73226

ST496

Manufactured

Manufactured

D3315-4

Wearplate

D3315-6

Wearplate

120 Each 1.0000 No Location Loc Qty Loc Code ST496 73228 120 Each 0.0000 No

Loc Qty

2

2

Loc Code

Page 1

Status

Date

											DQA:	Date:	
NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE												<u>.</u>	5.
QA Closed:											Date:		
Vork Order:						DISPOSITION			•	AGAINST DE	PARTMENT	PROCESS	
	Part No.					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other	
Root				- Desc	crit	otion of work order update		nitial	Act	tion	Sign &		
Cause	Date	Step	Qty	.80,		r Non-conformance	 Ch	ief Eng		ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther roccess upplier raining napproved													
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Landing	Gear					General				_	_		-
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion				BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration		Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
-	Turning S			"		Finish			Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G